

Date: Thursday, 27/11/2008 2:23:39 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 A/B HIGH GEAR WEB
Job Number :	43805		
Estimate Number :	10455		
P.O. Number :		Part Number :	D26543
This Issue :	27/11/2008	Drawing Number :	D2654 REV:E1
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	E1
Previous Run :	43120	Material :	
Written By :		Due Date :	10/12/2008
Checked & Approved By :	JUD 08.11.07	Qty:	2
Comment :	Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	35589

JD 8-12-8

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

JD 8-12-8

AWM

8-12-08

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 8-12-08 (2)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 43805

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD

8-12-8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G

AUM 8-12-08

(2)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/09 *HJ*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mr- 08-12-08

W/O:		WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

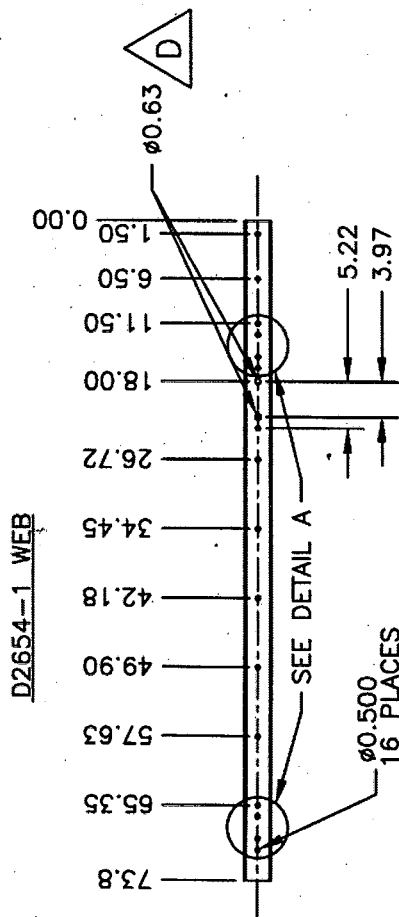
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

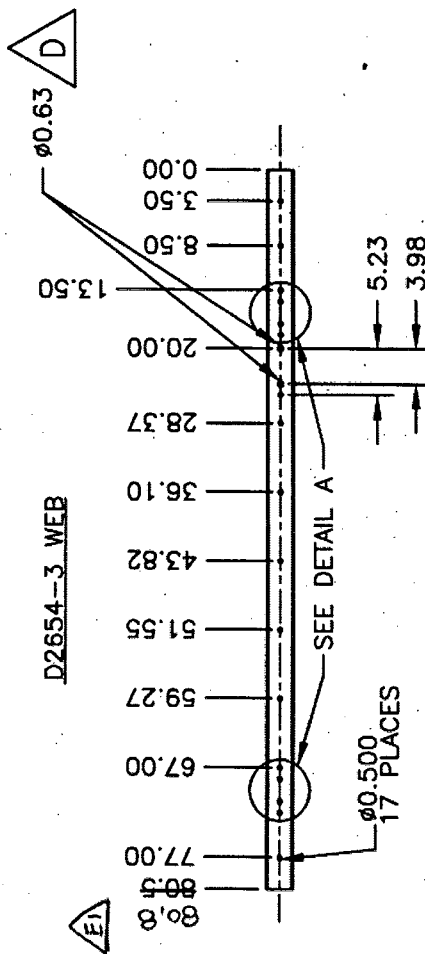
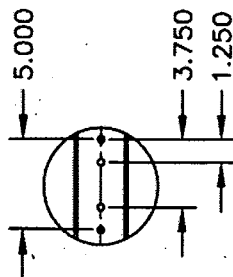


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. E
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D2654	SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	CP 04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22



DETAIL A
SCALE 1:10

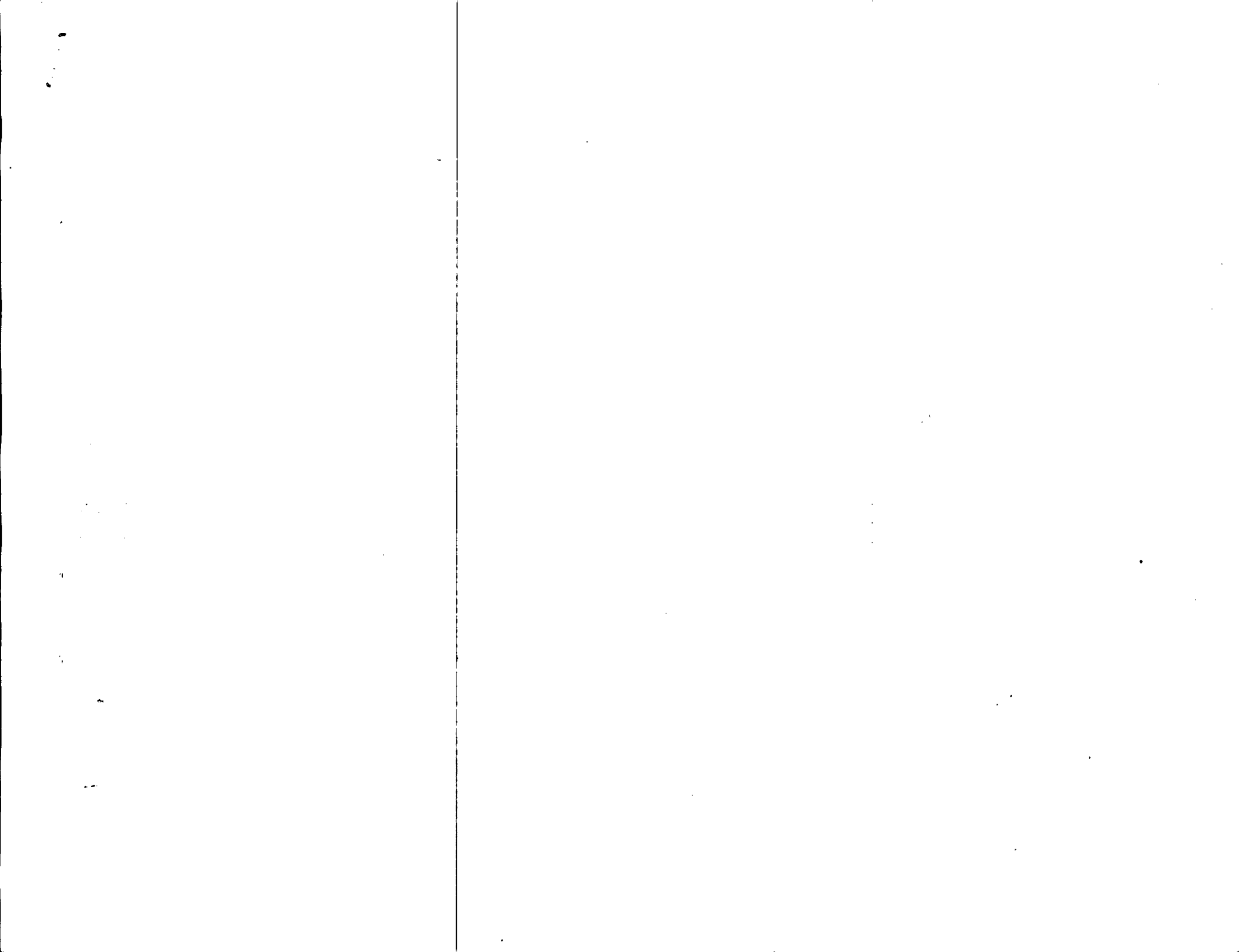


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WORK ORDER
NO. 43805

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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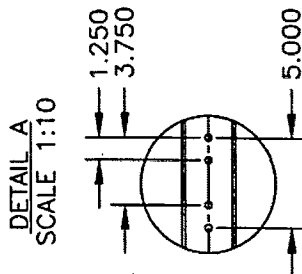
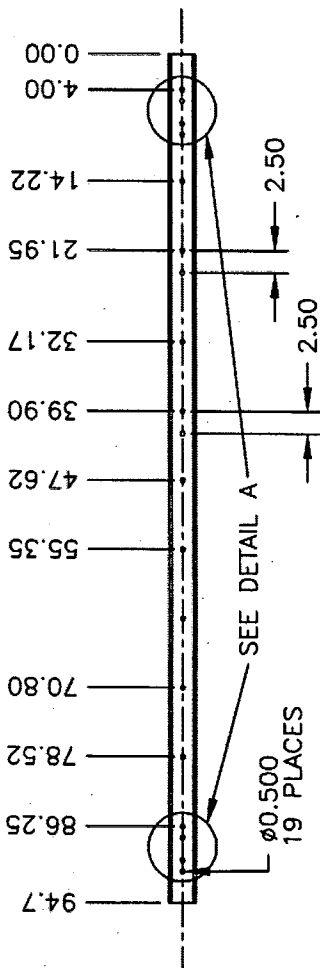




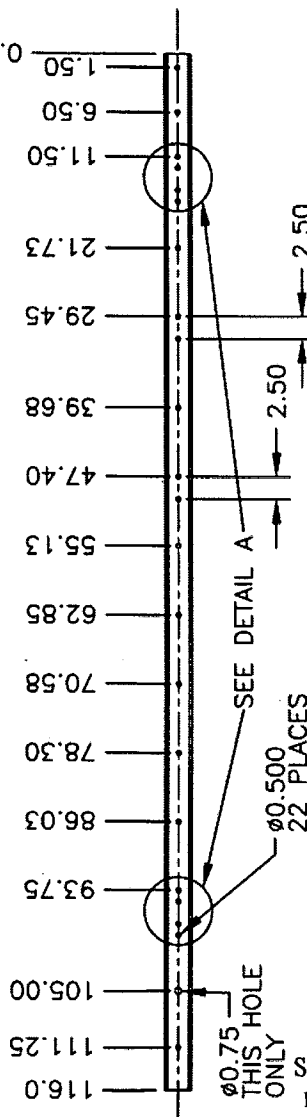
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB



D2654-7 WEB



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MAKE FROM D2600-7-125 EXTRUSION
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